

Date: Friday, 18/07/2008 1:09:57 PM  
 User: Julie Lecocq

## Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services			Drawing Name	: HELI ACCESS HANDLE WELDMENT ASSY, RH		
Job Number	: 40638			Part Number	: D2480012		
Estimate Number	: 10947			Drawing Number	: D2480 REV A1		
P.O. Number	:			Project Number	: N/A		
This Issue	: 18/07/2008 S.O. No. :			Drawing Revision	: A1		
Prsht Rev.	: NC			Material	:		
First Issue	: / / Type : LARGE FAB ASSY			Due Date	: 10/08/2008 Qty: 4 Um: Each		
Previous Run	: 38293						
Written By	:						
Checked & Approved By	: <u>JUL 08 7.18</u>						
Comment	: Est. C1 03.01.09 Added Powder Coat						

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :		
1.0	D2478	Heli-Access Handle		
		Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)		
		Lower Arm		
		Pick:		
		Qty	Part number	Description
		1	D2478	Heli Access Handle
				<u>B34632 ✓</u>
		Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)		
		Upper Arm		
		Pick:		
		Qty	Part number	Description
		1	D2479	Heli Access Handle
				<u>B340633 ✓</u>
2.0	D2479	Heli-Access Handle		
		Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)		
		Upper Arm		
		Pick:		
		Qty	Part number	Description
		1	D2479	Heli Access Handle
				<u>B340633 ✓</u>
3.0	D2481	Mounting Plate		
		Comment: Qty.: 2.0000 Each(s)/Unit Total : 8.0000 Each(s)		
		Lower Mount Plate		
		Pick:		
		Qty	Part number	Description
		2	D2481	Mounting Plate
				<u>B3410888 ✓</u>
4.0	D2482	Mounting Plate		
		Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)		
		Upper Mount Plate		
		Pick:		
		Qty	Part number	Description
		1	D2482	Mounting Plate
				<u>B323504 → 3 B38319 → 1 ✓</u>

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Friday, 18/07/2008 1:09:57 PM  
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## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: HELI ACCESS HANDLE WELDMENT ASS'Y, RH

Job Number: 40638

Part Number: D2480012

Job Number:



Seq. #: Machine Or Operation:

Description :

5.0 LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1  
Weld as per Template DT 8333 (DT 2480 CJ)

pd 08-08-14

(x4)

6.0 QC9

VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

08/08/14 (4)

7.0 QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

Job 08-14 (4)

8.0 POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.2) as per QSI 005 4.3

START TIME:

11:30

OVEN TEMPERATURE:

400

FINISH TIME:

12:00

M.L 08/08/18

(4X)

9.0 QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

8/8/18

50

10.0 PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location:

40614

8/8/18

50

(4X)

11.0 QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

08/08/2008

Job Completion



8/8/18

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

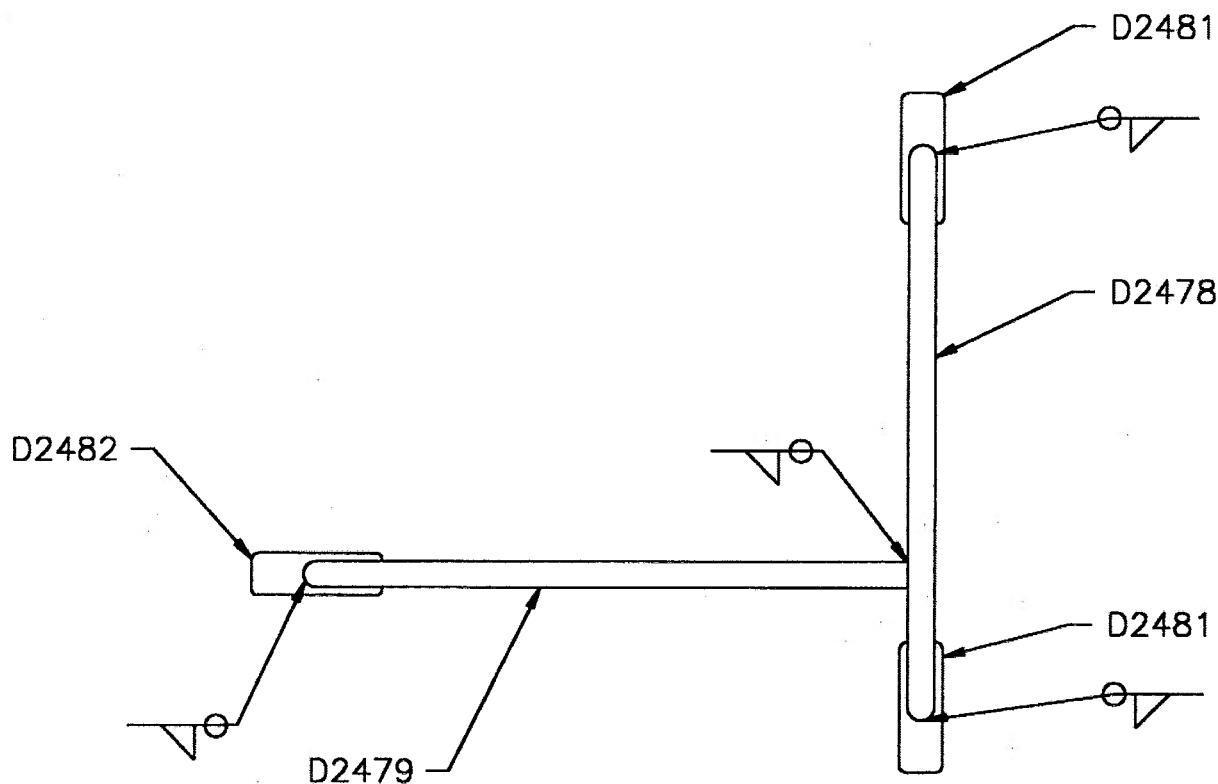
NOTE: Date & initial all entries

**DART**D COPY 1000  
07/06/96

DESIGN B WILLIAMS	DRAWN BY MIKE M	DART AEROSPACE LTD VICTORIA INTERNATIONAL AIRPORT, CANADA	
CHECKED <i>BW</i>	APPROVED <i>BW</i>	DRAWING NO. D2480	REV. A SHEET 1 OF 1
DATE 96:05:14		TITLE HANDLE WELDMENT ASSEMBLY	SCALE 6:1
		A1 <del>05.06.23</del>	ADDED POWDER COAT

**RELEASED**

96/06/02 DS



D2480-011 LH SHOWN  
D2480-012 RH OPPOSITE

## NOTES:

1) WELD PER TEMPLATE DT 2480 WG PER QSI 004  
 A1 2) POWDER COAT WHITE GLOSS (REF: 4,3,5,2) AS PER QSI 005

SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 40038